

Work Order ID 150530

Thursday, August 25, 2016 10:37:33 AM

150530

Page 1

Item ID: D5194-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 8/29/2016

Start Qty: 5.00

5 102m

Cust Item ID:

Required Date: 9/19/2016

Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5194

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(10)

22 16/09/07

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(10)

22 16/09/07

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(10)

DAS
38
9-89

SEP 07 2016

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Page 2

Item ID: D5194-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 8/29/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1
NC BRAKE

0.00

130

HandFinish

Memo

0.00

Hand Finishing

(10)

Ø

2016/09/07
BEB

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

(10)

DAS
38
9-89
SEP 08 2016

150

Identify as per dwg & Stock Location: St220

0.00

150

Packaging

Memo

0.00

Packaging

10

SEP 09 2016

DAS
6
9-89

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Page 3

Item ID: D5194-1**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Doubler**Start Date:** 8/29/2016 **Start Qty:** 5.00***5*****Cust Item ID:****Required Date:** 9/19/2016 **Req'd Qty:** 5.00***5*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

DAS
21
9-89

SEP 09 2016

DAS
21
9-89

SEP 09 2016

Picklist Print

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Page 1

Work Order ID: 150530

150530

Parent Item: D5194-1

D5194-1

Parent Item Name: Doubler

Start Date: 8/29/2016

Required Date: 9/19/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	91.4815		3.431579			
M6061T6S 0.32									**				
6061-T6 Sheet 0.032"													

22/12/09/07

Location

Loc Qty

Loc Code

MAT021

91.481497

m131352

48.1

m133757

43.381497

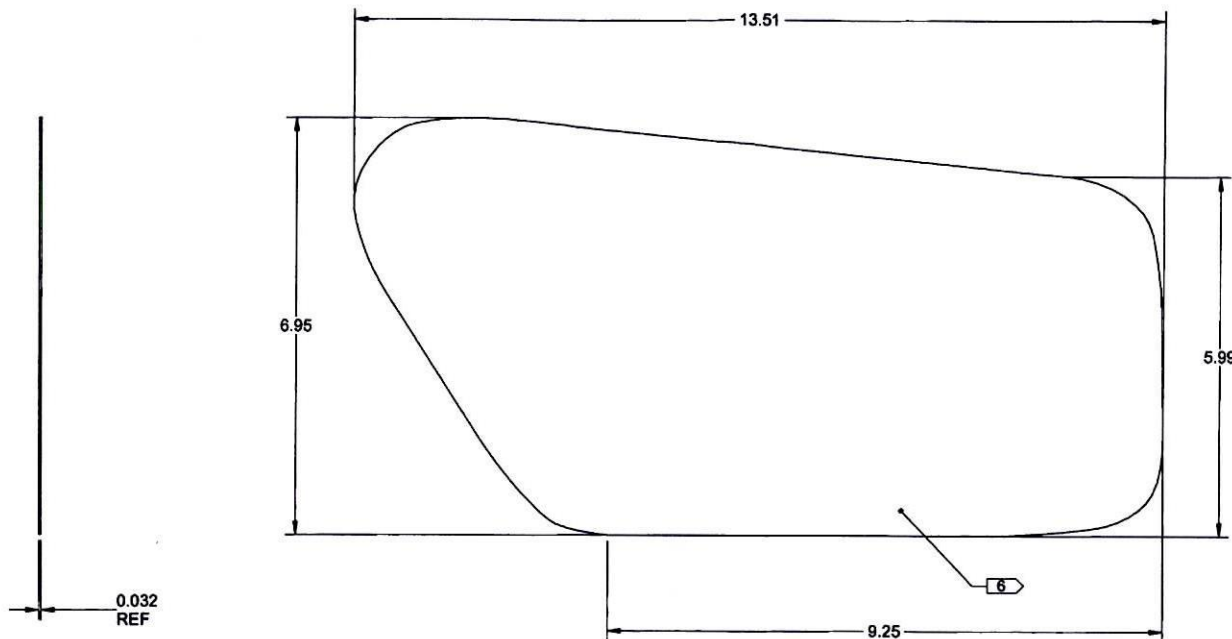
8

8 7 6 5 4 3 2 1

D

C

B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150530MLJ
160825

D5194-1 DOUBLER

RELEASED

2015 APR 30

ECN 15-527

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) CUT PER D5194-1.DXF. NON-DIMENSIONED FEATURES CONTROLLED BY D5194-1.SLDPRT

APPROVED

A NEW ISSUE		AK	14.11.20
REV.	DESCRIPTION		BY DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5194	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	14.11.20	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1